DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018421
Date Inspected: 13-Nov-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:
CWI Present: ☑ Yes ☐ No

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Trial Assembly, Tower and Sub assembly bay

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

CWR Verifications

B-CWR 2189 Rev 0 (Crack repair)
This QA Inspector was notified via email for verification of B – CWR 2081 R0 at 0930 hours the following was observed:
- The component for verification was identified as BK004A2-055
- Weld repair was required on an area where linear indication was observed by magnetic particle inspection on BK004A2-055-014, 015, 017, 019, 020
- ZPMC QC Liu Fa Wen was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-1G(1F)-Repair

B-CWR 2188 Rev 0 (Crack repair)
This QA Inspector was notified via email for verification of B – CWR 2088 R0 at 0940 hours the following was observed:
- The component for verification was identified as SA3357
- Weld repair was required on an area where linear indication was observed by magnetic particle inspection on

SA3357-001-009, 017
- ZPMC QC Zhan Hai Feng was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-2G(2F)-FCM-Repair

Trial Assembly (D-scan)
B-CWR 2185 Rev 1
This QA Inspector was notified via email for verification of B – CWR2185 R1 at 1400 hours the following was observed:
- The component for verification was identified as OBE11B-009 (11BE to 11CE side plate transverse splice @ C5)
- Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT)
- ZPMC QC An Qiang Xiang was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-3G(3F)-FCM-Repair-1 and WPS-345-SMAW-4G(4F)-FCM-Repair-1

B-CWR 2187 Rev 1
This QA Inspector was notified via email for verification of B – CWR2187 R1 at 1400 hours the following was observed:
- The component for verification was identified as OBE11B-008 (11BE+11CE bottom plate transverse splice)
- Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT)
- ZPMC QC An Qiang Xiang was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-1G(1F)-FCM-Repair-1 and WPS-345-SMAW-4G(4F)-FCM-Repair-1

Bay 3
B-CWR 2086 Rev 1
This QA Inspector was notified via email for verification of B – CWR 2086 R1 at 1400 hours the following was observed:
- The component for verification was identified as OBE11B-007 (11BE+11CE side panel transverse splice @ E7)
- Base metal repair was required on an area where base metal was gouged while repairing mill induced discontinuity
- ZPMC QC An Qiang Xiang was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-3G(3F)-FCM-Repair-1 and WPS-345-SMAW-4G(4F)-FCM-Repair-1

NWIT - 7343
This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of Tower components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. Weld identification numbers were

SSD1-TL5-1B-F-70A/B

WELDING INSPECTION REPORT

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QA Inspector generated a TL-6027 for this date

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer